

Date:
User:• Wednesday, 1/23/2008 11:26:12 AM
Kim Johnston

Process Sheet

6

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY
 Job Number : 36897
 Estimate Number : 10022
 P.O. Number :
 This Issue : 1/23/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LANDING GEAR
 Previous Run : 36896
 Written By :
 Checked & Approved By : KS 08 01 23
 Comment : Est Rev: P 02.08.28 Removed QC5 from Step 5 KJ

Part Number : D205634011
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material :
 Due Date : 2/7/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 08.01.25

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG005

AS 08/02/08

2.0 36897A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 36897A

AS 08/02/08

(X)

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	36308

AS 08/02/08

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/02/08

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: Rev. T

AS 08/02/08

SQ

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:26:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 36897

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/02/12

Job Completion



mic 2008/2/11 ①

W

36897A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
Job Number : 36897A
Estimate Number : 10023
P.O. Number :
This Issue : 1/23/2008 S.O. No. :
Prsht Rev. : NC Part Number : D205634041
First Issue : 1/1 Type : LANDING GEAR Drawing Number : D2580 REV D
Previous Run : 36896A Drawing Revision : D
Material :
Due Date : 2/7/2008 Qty: 1 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
Est Rev. O 06.02.28 Added paperwork EC
Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002

NA

2.0

D25001190

Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B34729

a.m 08.01.24

①

3.0

D2596

205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B34872

a.m

08.01.28

①

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

a.m

08.01.28

①

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

a.m

08.01.28

①

3-Acid etch and Alodine tube per QSI 005 4.1

a.m

08.01.28

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:26:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36897A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 08/07/28

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

a.m 08.01.28 ①

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

a.m 08.01.28 ①

3-Countersink holes as per Dwg D2580without cutting fluid

a.m 08.01.28 ①

4-Deburr and blow out all chips from inside of tube

a.m 08.01.28 ①

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M105469

Sikaflex expire date: 08.01

Start Time: 1:30 Date: 08.01.28

a.m 08.01.28 ①

Fin Time: 1:15 Date: 8-1-29

7.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

BE/11 8-1-29

2-Cut tubes as per Dwg. D2580

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

SL 8-1-29

2-Prepare tube for welding, remove alodine as required.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36897A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

in 05/09/07 @

10.0 D25763 Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	

B33321-1 BE 08/01/31

11.0 D2579 Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	

B30326 BE 08/01/29

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R Aluminum Rod

m 106390 BE 08/01/31

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill.

A/R Aluminum Rod

m 106390 BE 08/01/29

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

a.m 08.01.31 0

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

a.m 08.01.31 0

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg. D2580. Deburr holes

a.m 08.01.31 0

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

a.m 08.01.31 1

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

a.m 08.01.31 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36897A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JD 08-02-04 ①

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/04

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-1

08/02/04

①X

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M1106379

M-1

08/02/05

①X

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-02-05

①

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B35972

BR

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

11100188

BR

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

11104885

BR

BR

08-02-05

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36897A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

* 21.0

ALS71032130

Insert



ALS41032130

min 2008/2/11



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Insert

Batch: M 105729

BR

* 22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

BOLT

Batch: M106513

min 2008/2/11

BR

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

washer

Batch: M107008

BR

24.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B32744

BR

25.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: D36520

BR

26.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch: B36280

BR

27.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B36337

BR

BR 08-02-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:26:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36897A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	D356411	WEARSHOE
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B34805

BR

29.0	D35649	WEARSHOE
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B36637

BR

30.0	D35645	WEARSHOE
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B36538

BR

31.0	D25943	O-Ring
------	--------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: B27168

BR

32.0	D25941	Plug
------	--------	------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: B34790

BR

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: 08-07

M105585

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

BR 08-02-05 ①

BR 08-02-05 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 28/02/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:26:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36897A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

M 105585
08-07

08-02-05

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

M 106894

m-k

08/02/06 (X)

34.0

QC5

INSPECT WORK TO CURRENT STEP



08/2/07 (X)



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

30897

sd

AS 08/02/08

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/12

Job Completion



2008/2/11

h

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

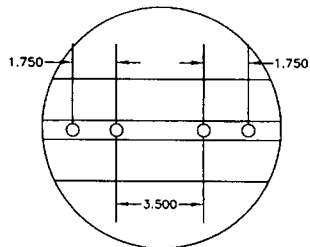
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36897A

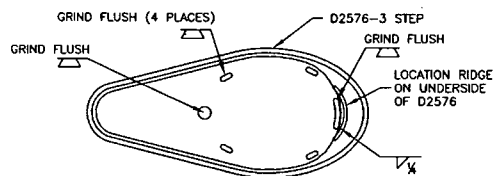
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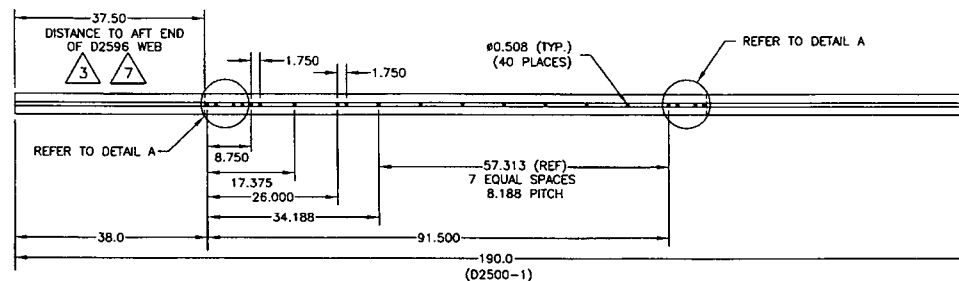
DETAIL A
SCALE 5:24



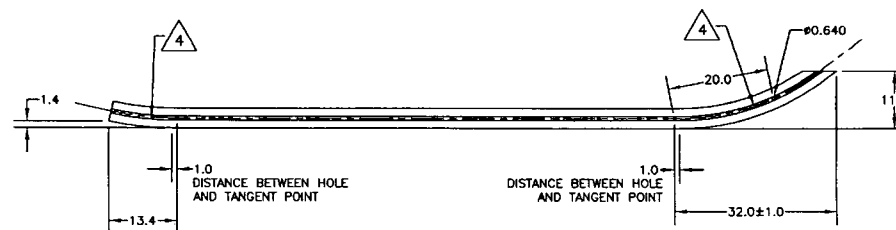
DETAIL B
SCALE 5:24



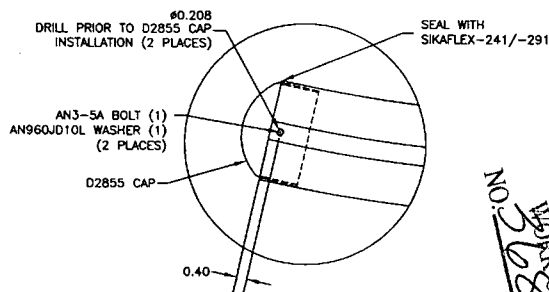
D2580-1 DRILLING DETAIL



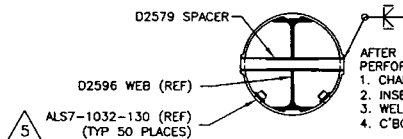
D2580-1 BENDING AND CUTTING DETAIL



DETAIL C
SCALE 5:24



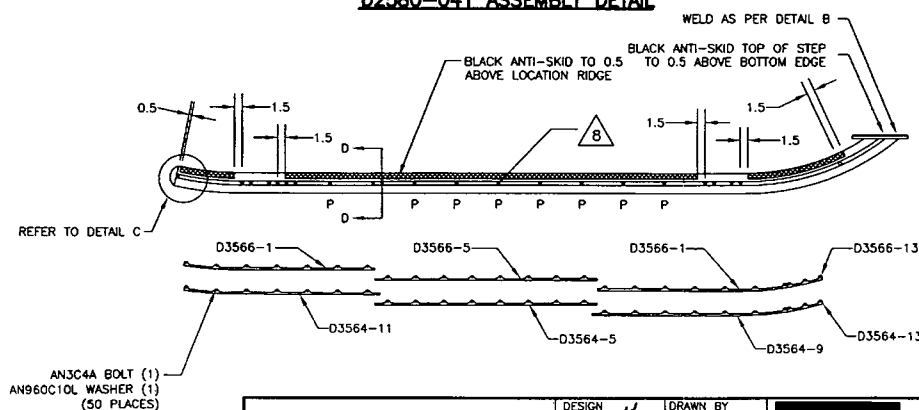
SECTION D-D
SCALE 5:24



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 NO. 36877A

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
 POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

RELEASED
07 Dec 28

Diagram illustrating the grinding locations for the propeller cross-section. The diagram shows a cross-section of a propeller with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component, likely a cap or seal, showing various parts and dimensions. The drawing includes the following callouts and dimensions:

- #0.208**: Dimension for the central hole.
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Instruction for drilling two locations.
- SEAL WITH SIKAFLEX-241/-291**: Material specification for the seal.
- AN3-SA BOLT (1)**: Specification for one bolt.
- AN960JD10L WASHER (1)**: Specification for one washer.
- (2 PLACES)**: Indication for two locations.
- D2855 CAP**: Identification of the cap part.
- SEE NOTE ii)**: Reference to a note.
- 0.40**: Dimension for a specific feature.

D2579 SPACER

WEB (REF)

F2579 (REF)

2. AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AENDME
WITHOUT NOTICE
WORK ORDER
NO 368977A

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750
17.375
26.000
34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0 91.500

190.0
(D2500-1)

Technical drawing of a horizontal curve showing dimensions and callouts. The drawing includes the following details:

- Dimensions:**
 - 51.340 (Total length)
 - 39.580 (Length from start to first hole)
 - 5.985 (Offset at start)
 - 5.338 (REF) (Offset at first hole)
 - 3.630 (REF) (Offset at second hole)
 - 5.915 (Offset at end of curve)
 - 1.4 (Offset at start of curve)
 - 1.0 (DISTANCE BETWEEN HOLE AND TANGENT POINT) (Twice)
 - 13.4 (Distance from start to first hole)
 - 32.0 ± 1.0 (Distance from second hole to end)
 - 20.0 (Radius of curve)
- Callouts:**
 - 4 (Triangle symbol at start and end of curve)
 - 4 (Triangle symbol at end of curve)
 - 4 (Triangle symbol at end of curve)
 - 4 (Triangle symbol at end of curve)
- Other Labels:**
 - 0.508 (8 PLACES) (Label for the curve)
 - 0.640 (Label for the curve)

[illegible]

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

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DRAWING NO.	REV. D
D2580	SHEET 3 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

NO. 141

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Borley E.
Joint Welding Procedure GTAW
Part number and Job number D 305 634 01 / B30721A

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS TIG
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08-02-01 Qualifier Pat Smith